

**Work Order ID 61558**

Page 1

Monday, August 30, 2010 11:22:00 AM

Item ID: D350-591-121

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, LH

Start Date: 8/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *H*Date: *10-8-30*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2351

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

*[Signature]**John BG 10-10-14*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

*10.09.27**[Signature]*

W/O: 61558		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/10/13	# 100.	Per. Chan.  update lengths to cut Abrasion strips + Rubber cushion. AND up Date heads box to ADD D350-591 Rev G.	AS	10.10.13			5 10/10/13

Part No: D350-591-121 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00



CNC Bend 1

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend.  
Program D2351-041.

10-10-4 (2)

130

0.00



QC

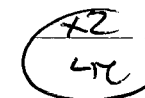
QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8/10/10/04



140

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel Fwd and Aft end for welding

10-10-04

2 8

2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033  
A/RAluminum Rod 114877

3-Do not Grind Flush

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.10.07

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/10/07

+2  
44

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

PK 10.10.07

2

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				2			
190 Large Fab Large Fab	Large Fab  Memo 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod <u>M108436</u> 3-Grind end cap flush per dwg D2351	0.00  0.00				2	φ		
220 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				②	PD	10.10.13	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D350-591-121	Accept		Setup	Start	
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Item Name: Heli-Access-Step, LH					
Start Date: 8/30/2010	Start Qty: 1.00		Cust Item ID:		
Required Date: 9/6/2010	Req'd Qty: 1.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		8/10/10/13		42 40			
240  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00		=> gl 10/10/13		241			
250  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 115091 Memo START TIME: 2:45 OVEN TEMPERATURE: 320° FINISH TIME: 8:15	0.00 0.00		10-10-13		241			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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260



HandFinish

Hand Finishing

Pressure Wash per QSI005-4-3  
Wing Walk Memo

Batch: M115026  
0.00

10/10/14

X2

0

270



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

2

10/10/15

280



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

10/10/14 50 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

290 QC4- 100% Inspect kits for completeness 0.00



QC Memo 0.00

Quality Control

2  
- kits bagged & separated & placed  
in step bag on step. Step Id'd with  
red decal.

300 Packaging 0.00



Packaging Memo 0.00

Packaging Identify and pack for shipping as per PPP D350-591-121

Location: RE  
PPP Rev: RE

10/10/10

310 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

10/10/18

10-10-13  
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, September 27, 2010 3:54:00 PM

Page 1

Work Order ID: 61558

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF  
IPP rev. F 06.02.23 added grinding EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-37A Bolt		Purchased	No				Each	666.0000	2	4		10/10/14 SP	
-----------------	--	-----------	----	--	--	--	------	----------	---	---	--	-------------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST353	666	
105425	166	
111668	500	

AN4-13A Bolt		Purchased	No				Each	480.0000	3	6		10/10/14 SP	
-----------------	--	-----------	----	--	--	--	------	----------	---	---	--	-------------	--

Location	Loc Qty	Loc Code
----------	---------	----------

ST358	480	
115159	480	

AN4-16A Bolt		Purchased	No				Each	278.0000	2	4		10/10/14 SP	Q2
-----------------	--	-----------	----	--	--	--	------	----------	---	---	--	-------------	----

Location	Loc Qty	Loc Code
----------	---------	----------

ST358	73	
115016	23	
115159	50	
ST360	205	
115422	100	

# Picklist Print

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Page 2

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Parent Item Name: Heli-Access-Step, LH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

AN960JD10  
Washer  
NAS1149D0363J Purchased No

Each 8.0000

4 8



M115622 10/10/14 SP

Location Loc Qty Loc Code

ST 6

107715 6

ST335 2

105792 2

AN960JD416  
Washer  
NAS1149D0463J Purchased No

Each 24.0000

6 12



10/10/14 SP M115647

Location Loc Qty Loc Code

ST300 24

113288 24

D2230-1  
Lug  
Manufactured No

Each 27.0000

1 2



B6713 10/10/14 SP

Location Loc Qty Loc Code

ST476 27

60289 27

D2230-3  
Lug  
Manufactured No

Each 70.0000

1 2



10/10/14 SP

Location Loc Qty Loc Code

ST476 70

55452 2

60846 68

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Shop Packet Print

Page 2



# Picklist Print

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Parent Item Name: Heli-Access-Step, LH

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

D2244-116

Manufactured No

Each

117.0000

0.5

1



Step Extrusion



10.9.27

Location

Loc Qty

Loc Code

WA

117

57850

32

60307

85

D2582

Manufactured No

Each

24.0000

1



Step Leg Assembly



10.10.12

Location

Loc Qty

Loc Code

WA

24

51343

3

53634

11

62053

10

D2673-34

Manufactured No

Each

170.0000

1



End Plate



10.10.12

Location

Loc Qty

Loc Code

WA

170

57527

1

59690

169

D2732-030

Manufactured No

Each

0.0000

2



Rubber Cushion



56516 10.10.14

D2850-1

Manufactured No

Each

10.0000

1



End Bracket



10.10.07

Location

Loc Qty

Loc Code

MEZZ

10

50267

10

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Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

D2856-400 *7-20<sup>u</sup>* Manufactured No



Abraison Strip

276.3760 0.6 1.2



*10/10/14 SP*

Location

Loc Qty

Loc Code

ST403

276.3760421

56626

63.2560421

59920 ✓

213.12

*12*

MS20600-AD4W3

Purchased No



Cherry Rivets

Each

1,571.000 16



32

*10.10.12*

Location

Loc Qty

Loc Code

ST321

1571

107939

822

111636

749

*32*

MS21042L3

Purchased No



Nut

Each

1,882.000 2



4

*10/10/14 SP 24*

Location

Loc Qty

Loc Code

ST300

1882

114523

109

114784 ✓

1773

*5*

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Parent Item Name: Heli-Access-Step, LH



Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

Each

4,555.000

3

6



Nut



*id: 1/14/10* *(32)*

Location

Loc Qty

Loc Code

ST300

4555

113422

68

114523

28

114718

16

114784

32

115108

1411

115589

1900

115621

1100

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
*6*  
\_\_\_\_\_  
\_\_\_\_\_

**DART**

DESIGN KE	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

**D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST**

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

\*cut per drawing

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41558  
PH 10-8-30

**RELEASED**  
05.11.28 #PH  
ECN 1105**UNDER REVIEW**07.11.29 #  
PER NCR # 263**Copyright © 1995 by DART AEROSPACE LTD**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

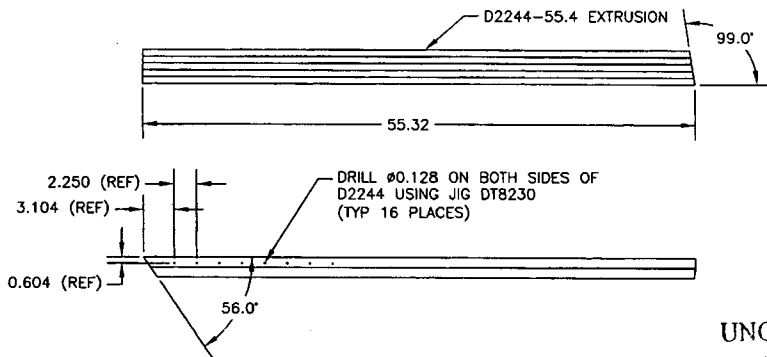
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

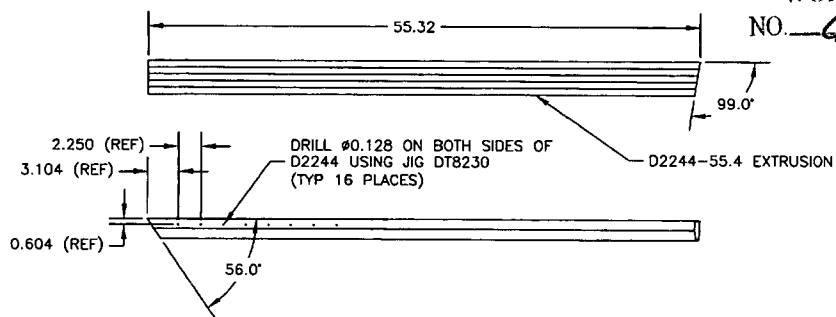
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NOTE: Date & initial all entries

D2351-2 CUTTING/DRILLING DETAIL  
RIGHT STEP

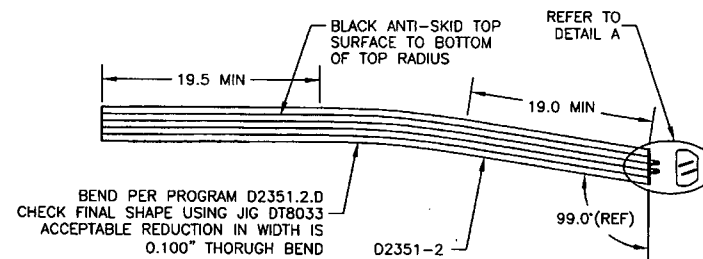


D2351-1 CUTTING/DRILLING DETAIL  
LEFT STEP

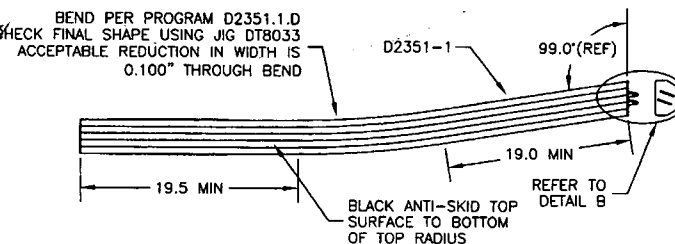


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ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *41555*  
*2810-8-30*

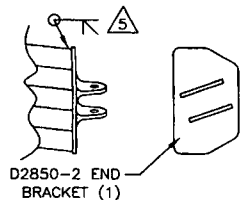
D2351-042 BENDING/ASSEMBLY DETAIL  
RIGHT STEP



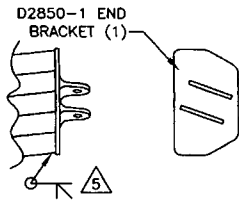
D2351-041 BENDING/ASSEMBLY DETAIL  
LEFT STEP



D2582 STEP LEG ASSEMBLY (1)



DETAIL A  
SCALE: 1:4

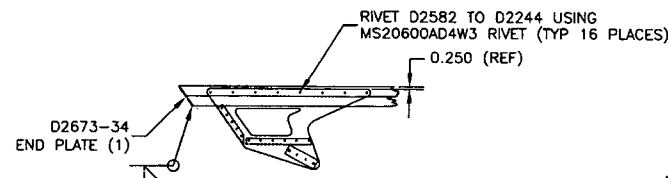


DETAIL B  
SCALE: 1:4

GENERAL NOTES

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.



RELEASED  
05.11.28

UNDER REVIEW

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DESIGN KE	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SHEET 2 OF 2
			SCALE 1:12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1 ✓	1	1	1	D2230-1	MOUNTING LUG
1 ✓	1	1	1	D2230-3	MOUNTING LUG
1 ✓	1	1	1	D2856-400-720	ABRASION STRIP
2 ✓	2	2	2	AN3-37A	BOLT
3 ✓	3	3	3	AN4-13A	BOLT
4 ✓	4	4	4	AN960JD10	WASHER
6 ✓	6	6	6	AN960JD416	WASHER
2 ✓	2	2	2	MS21042L3	NUT
3 ✓	3	3	3	MS21042L4	NUT



REFERENCE ONLY

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER  
AND  
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER  
REF CANADIAN STC: SH92-6  
REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

## ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X				D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X			D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X		D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
				X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT







The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)

DATE: 09.06.24  
CERT. NO.: SH92-6  
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		REV. B	
CHECKED		DRAWING NO. DSI 9459	
MFG. APPR.		SHEET 1 OF 2	
APPROVED		TITLE	
DE APPR.		OPTIONAL CLAMP MODIFICATIONS	
DATE	09.06.24	SCALE NTS	
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